Work Orde June-16-14 8:50						Page 1	l						
	D3564-9	9	F	Accept	*N900	040	100)*	Setup	Start	*NI	S1*	_
Revision ID: Item Name:	Stainless	Steel Wearplate Fwd								Stop		S2*	
Start Date: Required Date: Reference:	6/16/14 6/16/14	Start Qty: 16.00 Req'd Qty: 16.00	*16* *16*		Cust Item Customer:	ID:							
		s Plan: ML5	Date: 14-06-16			ate:		•	Run	Start Stop	*N	R1*	
Sequence ID/ Work Center ID		Operation Description	Date:	SPC (Y/N): Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej		Reject Number	Insp. Stamp	
Draw Nbr		Revision Nbr											
D3564		Rev D	•										
100 *1 \\\ Waterjet		FLOW WATER JET		0.00				15	·	R	14-6	1-16	
FLOW CNC Waterje	t	Memo 1-Cut as per Rev:	Dwg D3564 *****(D3564 2-Deburr if necessary		Prog								
110 💝		QC2- Inspect parts off ma	achine FAI/FAIB	0.00									
110 QC Quality Control		Memo		0.00				15		<u>R</u> ,	1461	16	

120

QC8- Inspect parts - second check

120

0.00

Quality Control

Memo

Work Order: Date: Disposition AGAINST DEPARTMENT/PROCESS	DQA:			Date:							"DART			
Work Order: Part No.	OA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UPD		Vork Order ut	odate only	AEROSPACE
Rework Skid-tube Crosstube Nater Jet Engineering Quality Other Quali	QA Closed.		 -	Dutc.									· 1	
Rework Scrap Skid-tube Crosstube Prod. Eng. Coor. Quality Machining Small Fab Prod. Eng. Coor. Quality Machining Engineering Prod. Eng. Coor. Quality Engineering Prod. Eng. Coor. Quality Machining Engineering Prod. Eng. Coor. Quality Prod. Eng. Eng. Eng. Eng. Eng. Eng. Eng. Eng	Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
NCR No. Use-as-is Suspected Unapproved Use-as-is Large Fab Composite Finishing Rec/Store/Packaging Other Supplier Other Cause Date Step Qty Description of work order update Or non-conformance Chief Eng Description Date Verification QC Inspector Date Date Verification QC Inspector Date Dat		•					Rework]		Skid-tube	Crosstube	٦	Water Jet	Engineering
Root Cause Date Step Qty Description of work order update Cause Date Step Qty Description of work order update Cause Date Step Qty Description of work order update Chief Eng Description Description Date Verification QC Inspector Design Description Description Date Verification QC Inspector Description Date Verification Date Verification QC Inspector Description Date Verification Date Verific	Part N	lo.					Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
Root Cause Date Step Qty Description of work order update or non-conformance Chief Eng Description Date Verification QC Inspector Design Doc/Data Description Date Verification QC Inspector Design Doc/Data Date Date Verification QC Inspector Design Doc/Data Date Date Date Date Date Date Date		•					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
Cause	NCR N	lo.					Suspected Unapproved			Large Fab (Composite _		Supplier	
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Design Doc/Data	Root		_			Desci	·	1				_		06 lu ana arta n
Doc/Data		4	Date	Step	Qty		or non-conformance	Ch	net Eng	Descript	tion	Date	Verification	QC inspector
Equip/Tooling Handling/Pre Hand	· · -													
Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapprove Unapprove Dending Gear General Landing Gear General Bending Centre Not Concentric BOM/Route Folio/Program Over/Under tolerance Set-up												Í		
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Process Supplier Training Transport Unapproved Unapproved Bending Centre Not Concentric BOM/Route FOlio/Program Grain														44
Supplier Training Transport Unapproved Unapproved Landing Gear General Bending Centre Not Concentric BOM/Route Grain Grain														
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Unapproved FAULT CATEGORY Landing Gear General Bending Bend Folio/Program Outside Dimensions Pressure/Forced Centre Not Concentric BOM/Route Grain Over/Under tolerance Set-up	l													
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Bending Bend Folio/Program Outside Dimensions Pressure/Forced Centre Not Concentric BOM/Route Grain Over/Under tolerance Set-up						4		FA	ULT CA	TEGORY				<u></u>
Centre Not Concentric BOM/Route Grain Over/Under tolerance Set-up	Landir	ng (Sear			_	1	_	,			_	_	–
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Turning Sequence Finish Out of Calibration			1			\vdash			4					
Wave/Twist in Tube Fit/Function Out of Sequence			1				-	\vdash	-					

Work Ord June-16-14 8:5		0930		*120	1930*							Page 2	2
Item ID: Revision ID: Item Name:	D3564-9	Wearplate Fwd		Accept	*N900	<u> </u>	1100)*	Setup	Start Stop	I.V	S1*	
Start Date: Required Date: Reference:	6/16/14	Start Qty: 16.00 Req'd Qty: 16.00	*16* *16*		Cust Item ID: Customer:						^1\\	S2*	
Approvals:	Process Pla	n:	Date:	Tooling:	D	ate:			Run	Start	*N	R1*	
	QC:		Date:	SPC (Y/N):	Date:					Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Code DAS	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	— 1 (
130		NC BRAKE					30 9-89	15				14	low
Brake NC Brake NC			essaryForm on Brake as po n Joggle as per Dwg D356					·					36 9-89
¹⁴⁰ *1△∩ *		QC5- Inspect part comple	teness to step on W/O	0.00 PS	7,			K					
QC Quality Control		Memo	e as per dwg D3429	0.00	127			()					

150

150 Large Fab

Large Fab

Large Fab

Memo

Oty 92 Bescription BatchA/R With 92 Weld hardcoat as per Dwg D3564

0.00

0.002059B Hardcoat 15 14-07-03 MAL

DQA:			Date:				AAC							
						WORK ORDER NON-	·CC	ONFO	RMANCE / UPDATE				_	AEROSPACE
QA Closed:			Date:							W	ork Order up	odate only		
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Part N	lo.					Scrap			Machining Small Fab	_	Pro	d. Eng. Coor.	٦	Quality
* .	-					Use-as-is		Thern	noforming Finishing		Rec/Sto	re/Packaging		Other 🗌
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Root					Desc	ription of work order update		nitial	Action		Sign &		Т	
Cause		Date	Step	Qty	Desc	or non-conformance		ief Eng	Description		Date	Verification		QC Inspector
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Landi						General		1			٦	· .	_	
	\vdash	Bending				Bend	_	1	Program	-	Outside Dim	<u> </u>	_	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	⊢	_	Set-up
· ·		Cracks		6		Broken/Damage/Defect	_	Hardwa	•	\vdash	Part Incorred	—		Femperature/Cure
	_	Crimp/Kir	ik/Ripple	/Wave	<u> </u>	Burrs		1	ion Incomplete/Unqualified	\vdash	Part Lost/Mi	ssing	_	Weld
	-	Cuffs			-	Contamination		4	tions Incomplete/Unclear	\vdash	Part Moved	L	الـــ	Wrong Stock Pulled
	-	Crushing			\vdash	Countersink Cut Too Short	_	Mislabe	gned/off center	\vdash	Positioned V Power Loss/		\neg	Other
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,	$\vdash \vdash$	Marks/Ch		rube	-	Drill Holes		Off-set						
	\vdash	Turning S			-	Finish	\vdash	4	Calibration		-			
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l						1,		1			<u> </u>			

Work Order ID	12093
June-16-14 8:50:03 AM	

120930

Page 3

Stop Stop Stop Start Date: Start Date: Stop Start Date: Start	ine-16-14 8:5		
Start Date: 6/16/14 Start Qty: 16.00 *16* Cust Item ID:	evision ID:	14.71	=
Approvals: Process Plan: Date: Tooling: Date: SPC (Y/N):	equired Date:		
Work Center ID Description QC10- Inspect visual per QS1004- ground welds 0.00 *160 QC10- Inspect visual per QS1004- ground welds QC Memo 0.00 DAS 27 4170* QC Memo 0.00 Memo 0.00 Memo 0.00 Memo 0.00 DAS 27 489 Memo 0.00	pprovals:	"INH I"	
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DQA:			_ Date:				ON-CONFORMANCE / UPDATE						-	DART	
QA Closed:			Date:			WORK ORDER NON-	-((JNFO	RIVIANCE / UI	PDATE	Wo	ork Order up	odate only	7	AEROSPACE
						DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
Work Orde	er: -					, _, ,	. 1		G1:14.15.	C			Mater let	٦.	nginooring
						Rework			Skid-tube	Crosstube Small Fab		Dro	Water Jet	⊣ ՟	ngineering Quality
Part N	١٥					Scrap			Machining noforming	Small Fab Finishing			d. Eng. Coor. re/Packaging	┥	Other
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l	1	wave/fv	vist in Tul	oe e		Fit/Function		Jout of	Sequence						

Work Ord June-16-14 8:5		20930		*120	930*							Page	÷ 4
Item ID: Revision ID: Item Name:	D3564-9 Stainless Stee	el Wearplate Fwd	WA 100 100 100 100 100 100 100 100 100 10	Accept	*N900	040	10	n *	Setup	Start Stop		S1*	a to the whole where
Start Date: Required Date: Reference:	6/16/14	Start Qty: 16.00 Req'd Qty: 16.00	*16* *16*		Cust Item 1 Customer:	ID:					, ,		
Approvals:	Process Pla	an:	Date:	Tooling:	D:	ate:			Run	Start	*N	R1 *	
	QC:		Date:	SPC (Y/N):	D:	ate:				Stop	*N	R2*	
Sequence ID/ Work Center I 190 *1 QA* QC Quality Control	D	Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Oty	Rej Qty		Reject Number	Insp. Stamp	
200 */ On* Packaging Packaging		Identify as per dwg & Stoo Memo	ck Location: FP-OC	0.00 0.00				XIS	- 4			1407	≤ \\}

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210

21 N

Quality Control

QC21- Final Inspection - Work Order Release

Memo

MU-7-14

DQA:			Date:			·	ON-CONFORMANCE / UPDATE						"DART
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UI		Vork Order up	odate only	AEROSPĀCĒ
						DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Work Orde	r: -						,				٦)4/a4a# la4	T Furtime and a
D 4 N				*		Rework			Skid-tube	Crosstube Small Fab	- Dro	Water Jet d. Eng. Coor.	Engineering Quality
Part N	0.					Scrap Use-as-is			Machining noforming	Finishing	⊣	re/Packaging	Other
NCR N	l۵					Suspected Unapproved		111611	Large Fab	Composite	- 1100,510	Supplier	1
iven i	· · ·						1						
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Design													
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Handling/Pre	_												
Material	_												
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						General	FA	ULT CA	TEGORY			· 	
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	-	Bending Centre No	nt Concor	atric	\vdash	BOM/Route	\vdash	Grain	Togram	-	Over/Under	├ ─	Set-up
}	_	Cracks	ot concer	ittic	-	Broken/Damage/Defect	\vdash	Hardwa	are	<u> </u>	Part Incorre	<u> </u>	Temperature/Cure
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	_	Cuffs	ik) Kippie	/ wave		Contamination	\vdash	4 '	tions Incomplete/l	<u>-</u>	Part Moved		Wrong Stock Pulled
		Crushing				Countersink	\vdash	-	gned/off center		Positioned V	∟ Vrong	~
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	_	Inspectio		Tube		Drawing		Misrea		L.	·	· _	
		Marks/Ch				Drill Holes		Off-set					
					 	Finish		4	Calibration				
	Turning Sequence Wave/Twist in Tube					Fit/Function		Out of	Sequence				

Page 1

Work Order ID: 120930

120930

Parent Item:

D3564-9

D3564-9

Parent Item Name:

Stainless Steel Wearplate Fwd

Start Date: 6/16/14

Required Date: 6/16/14

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP Rev:A

New Issue 07-03-08 ec

IPP Rev:B

As per Rev C 07-07-09 JLM

IPP Rev:C

As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Qty per K Hand	it Total Qty	Qty Date Issued Issu	Status
M304S16GA		Purchased	No		100	sf	416.8070 1.41	24		
M304S16	GA						**	A	14.6-11	

304/316 Sheet .063

Location	Loc Oty	Loc Code	
MAT020	416.807		
M127821	75.567		
M128423	1.2		
M129192	20.04		
W1129449	320		16

DQA:		****	Date:			. WORK ORDER MON	ON-CONFORMANCE / UPDATE							DART
QA Closed:			Date:			WORK ORDER NON-	٠. در	JNFOI	KIVIANCE / UF		Vork Order up	odate only	丄	AEROSPÄCE
						DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS		•
Work Orde	er:					D	ì		المطيعة المتارية	Crasstuba	7	Water Jet	\neg	Engineering
O a sak A	1 -					Rework			Skid-tube Machining	Crosstube Small Fab	- Pro	d. Eng. Coor.	\dashv	Engineering Quality
Part N	۱O					Scrap Use-as-is		l	noforming	Finishing	_	re/Packaging	\dashv	Other
NCR N	do					Suspected Unapproved			Large Fab	Composite	1 1100/3101	Supplier	+	
NCK	v O.					Suspected Ollappioved			carge rab	Composite				
Root					Desc	ription of work order update	- 1	nitial	Acti	ion	Sign &		T	
Cause		Date	Step	Qty		or non-conformance	Ċh	ief Eng	Descri	iption	Date	Verification		QC Inspector
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4 19		<u> </u>					FAI	ULI CA	TEGORY				—	
Landi	ng (1				General Bend		ا دمانه (د	Program		Outside Dim	ensions [٦,,	ressure/Forced
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	⊢	Centre No Cracks	ot concer	IUIC	-	Broken/Damage/Defect	\vdash	Hardwa	are	-	Part Incorre	-		emperature/Cure
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	 	Cuffs	ilk/ilippie	/ wave		Contamination	\vdash	4	tions Incomplete/U	-	Part Moved	F	_	rong Stock Pulled
		Crushing			 	Countersink	\vdash	4	gned/off center	-	Positioned V	∟ Vrong		
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	\vdash	Inspectio		Tube	\vdash	Drawing	\vdash	Misrea		L		~ L		
	<u> </u>	Marks/Cl				Drill Holes		Off-set						
	_	1				Finish		4	Calibration					
	Turning Sequence Wave/Twist in Tube					Fit/Function		Out of	Sequence					

DART AEROSPACE LTD	Work Order:	120930
Description: Wearshoe	Part Number:	D3564-9
Inspection Dwg: D3564 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

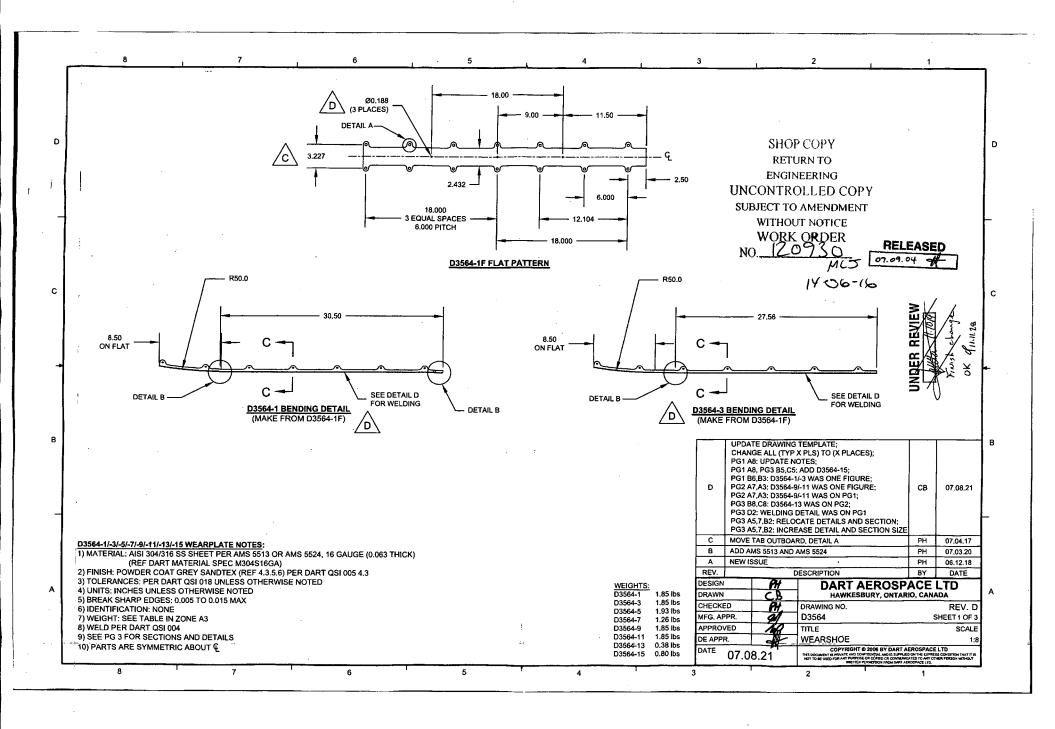
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.221			1 Shmos	
2.432	+/-0.010	2.437			105	
2.50	+/-0.030	2.25	/			
6.000	+/-0.010	6.				
12.104	+/-0.010	12.104	1	1	JKM OB	
18.000	+/-0.010	14	-/-	,		
18.000	+/-0.010	18				
18.00	+/-0.030	18	1			
9.00	+/-0.030	9.			·	
11.50	+/-0.030	11.5				
0.300 x 0.300	+/-0.010	0.30/x6363				
Ø0.188	+0.005/-0.001	\$ 0.188				***
R0.375	+/-0.010	R.0375	/	-		
0.063	+/-0.010	0.061	1			
	- T					

Measured by: Audited by: B 27 9-89 Prototype Approval: N/A

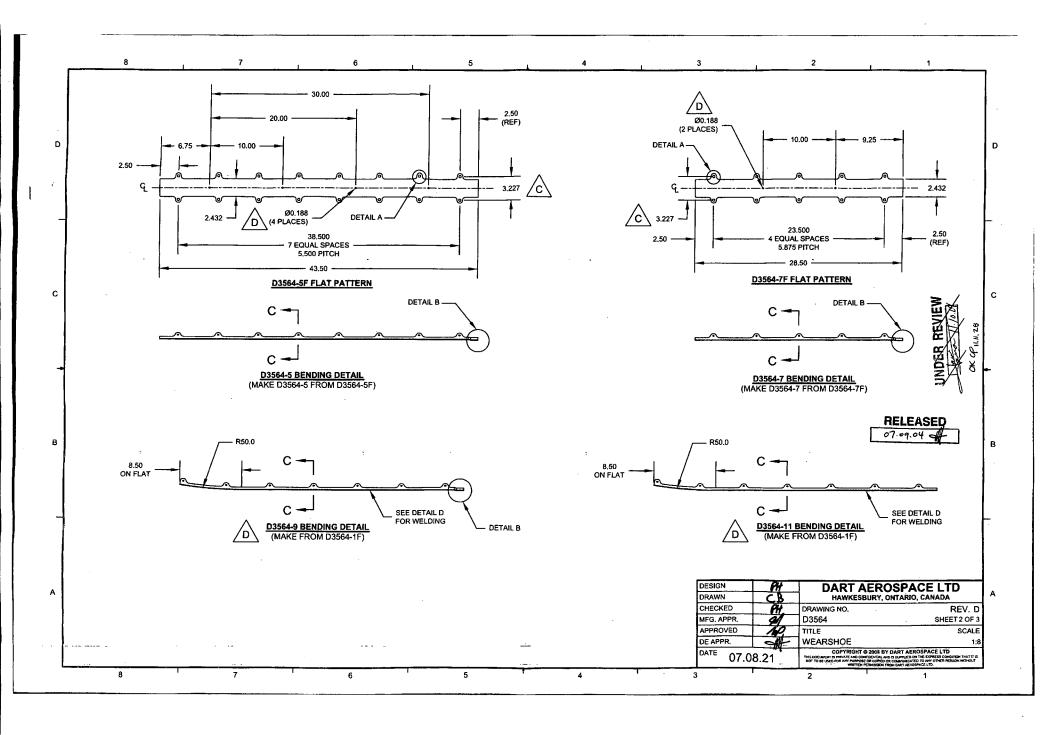
Date: 14-6-16 Date: 14/6/17 Date: N/A

Rev	Date	Change	Revised by	Approved
Α	08.01.16	New Issue	KJ/EC/DD	<i>X</i>

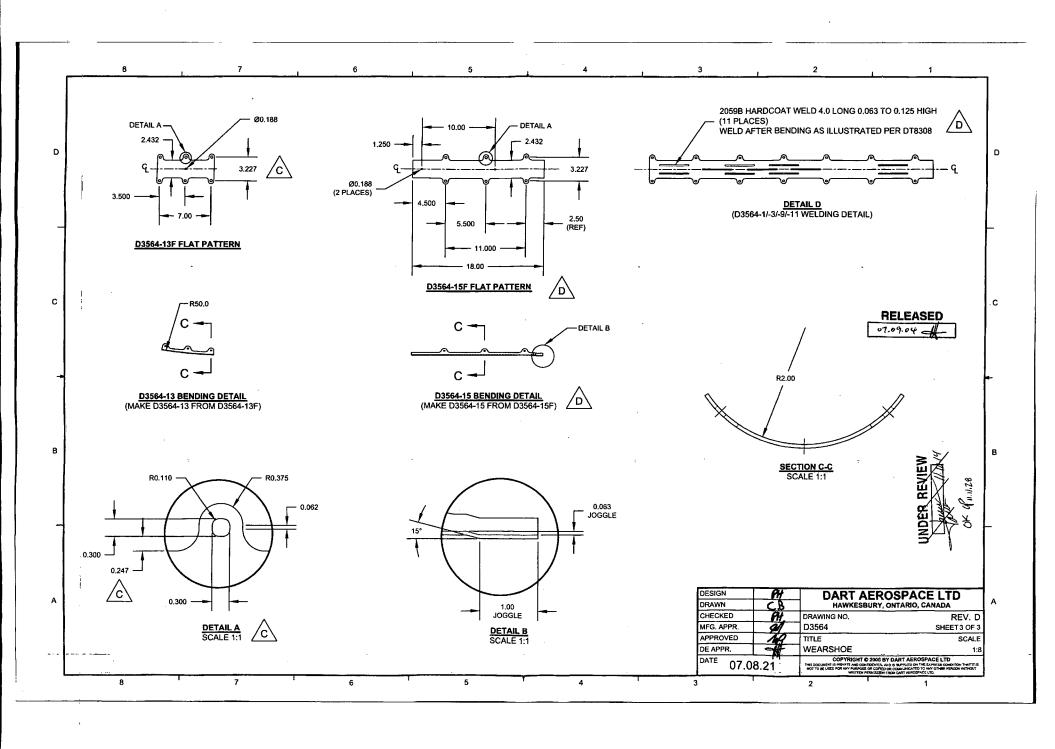
DQA:		- Date:			WORK ORDER NON-CONFORMANCE / UPDATE								"DART	
QA Closed:		Date:			WORK ORDER NON-	Work Order update only								
 					DISPOSITION	ION AGAINST DEPARTMENT/PROCESS								
Work Orde	er:				ر <i>ـــ</i>	.			,		•			
					Rework			Skid-tube	Crosstube			Water Jet	Engineering	
Part N	lo.				Scrap			Machining	Small Fab	\square		d. Eng. Coor.	_	Quality
					Use-as-is			noforming	Finishing	_	Rec/Stor	e/Packaging	_	Other
NCR N	lo				Suspected Unapproved	J		Large Fab	ab Composite Supplier					
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l	Centre N	lot Conce	ntric		BOM/Route		Grain			П	Over/Under	tolerance		Set-up
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i	Crimp/Kink/Ripple/Wave				Burrs		Inspect	ion Incomplete/U	nqualified		Part Lost/Mi	ssing		Weld
	Cuffs				Contamination		Instruct	ions Incomplete/	Unclear		Part Moved			Wrong Stock Pulled
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Ì	Heat Tre				Cut Too Short		Mislabe	eled			Power Loss/	Surge		Other
	Inspection	n Strip in	Tube		Drawing		Misrea	d						
	Marks/C	hatter			Drill Holes		Off-set							
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